Dart Aerospace Ltd.

Date: Thursday, 1/25/2007 10:24:42 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 30463		
Estimate Number	: 10274		
P.O. Number	: N/A	**Part Number**	: D350591312
This Issue	: 1/25/2007 **S.O. No.** : N/A	**Drawing Number**	: D3272 REV A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: A
Previous Run	: 30181	**Material**	: N/A
Written By	:	**Due Date**	: 2/28/2007 **Qty:** 12 **Um:** Each
Checked & Approved By	: 07.01.25		
Comment	: Est Rev:A 04.03.22 New issue KJ/RF		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and type labels as per PPP D350-591-311 CHG001 KS 07.02.08 (12)

2.0	D2622120C	Extrusion

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2622-120	Extrusion	330199

07.05.04 12

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A 07.05.04 12

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. 07.05.04 12

3-Deburr 07.05.04 12

4.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/05/08 (12)

5.0	D30671	End Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:
Qty Part Number Description Batch

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30463 **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
	1 D3067-1 End Plate 30559	07-05-08 12
6.0	D32191	Support

Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D3219-1 Support B30562 = 5
B31837 = 19
07.05.08 12

Seq. #:	Machine Or Operation:	Description :
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY 07-05-08 12

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 07-05-09 12
A/R Aluminum Rod M102756
M103317

3-Grind End Plate flush FF 07-05-09 12

Seq. #:	Machine Or Operation:	Description :
8.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/05/09 (12)

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/05/09 (12)

Seq. #:	Machine Or Operation:	Description :
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 HD 07-05-16 (12)

Seq. #:	Machine Or Operation:	Description :
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 07-05-17 (12)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B. Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:24:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30463 **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D3065041	Step Leg Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3065-041 Step Leg Assy 330466 07-05-17 | 12

13.0	D30661	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D3066-1 Spacer 330558

14.0	MS20600AD4W4	Rivets

Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)
Pick:
Qty Part Number Description Batch M102250 (=3)
16 MS20600AD4W4 Rivet M103481 = (138) M104106 = (51)

15.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
Assemble Leg Assembly as per Dwg D3272. 07-05-17 | 12

16.0	QC5	INSPECT WORK TO CURRENT STEP

070517 RH 10

Comment: INSPECT WORK TO CURRENT STEP

17.0	D30671	End Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3067-1 End Plate 330559 07-05-17 | 12

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:24:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30463
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding — L.E. 07-05-17 12

2-Inspect for foreign object as per QSI 024 — L.E. 07-05-17 12

3-Weld Aft End Plate as per QSI 004 & Dwg D3272 — L.E. 07-05-17 12
A/R Aluminum Rod M/02756

4-Grind End Plate flush — FF 07-05-18 12

Seq. #:	Machine Or Operation:	Description :
19.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION — 07/05/18 (12)

Seq. #:	Machine Or Operation:	Description :
20.0	QC5	INSPECT WORK TO CURRENT STEP

07-05-18 (12 RH)

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Touch up Alodine — 07/05/24 (12)

Seq. #:	Machine Or Operation:	Description :
22.0	POWDER COATING	POWDER COATING

M/ 103141 (12X)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 — 07/05/28

Seq. #:	Machine Or Operation:	Description :
23.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

M/07281

Comment: HAND FINISHING RESOURCE #1
Wing Walk as per Dwg D3272 and QSI 005 4.4 — 07/05/28 (12)

Seq. #:	Machine Or Operation:	Description :
24.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: Inspect Powder Coat and Wing Walk — 7/5/29 12

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:24:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30463 **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
26.0	D22303	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-3	Mounting Lug	B30545 (24x) X B29806 (24x) X

Seq. #:	Machine Or Operation:	Description :
27.0	D2618	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2618	Bushing	B30465 X

Seq. #:	Machine Or Operation:	Description :
28.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 7.2000 f(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2856-400-720	Abrasion Strip	B30822 X

Seq. #:	Machine Or Operation:	Description :
29.0	D32351	Mounting Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3235-1	Mounting Lug	B30050 X

Seq. #:	Machine Or Operation:	Description :
30.0	D3278041	Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D3278-041	Support Assembly	B30563 X

07/05/22

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:24:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30463 **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	AN335A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 AN3-35A Bolt M102339 X

Seq. #:	Machine Or Operation:	Description :
32.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 AN4-13A Bolt M104156 X

Seq. #:	Machine Or Operation:	Description :
33.0	AN536A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 AN5-36A Bolt M103177 X

Seq. #:	Machine Or Operation:	Description :
34.0	AN960JD10	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD10 Washer M104322 X

Seq. #:	Machine Or Operation:	Description :
35.0	AN960JD416	Washer

Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
16 AN960JD416 Washer M102929 X

Seq. #:	Machine Or Operation:	Description :
36.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M103641 X

[signature] 4/25/2022 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes / No (circled: No) **DQA:** [signature] **Date:** 07/05/29

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:24:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30463
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
37.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M103641

Seq. #:	Machine Or Operation:	Description :
38.0	MS21042L4	Nut

Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 MS21042L4 Nut (or -4) M102552

Seq. #:	Machine Or Operation:	Description :
39.0	MS21042L5	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L5 Nut (or -5) M102536

07/05/22 (12)

Seq. #:	Machine Or Operation:	Description :
40.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

07/05/29 (12)

Comment: INSPECT 100% KITS FOR COMPLETENESS

7/05/29 (12)

Seq. #:	Machine Or Operation:	Description :
41.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-591-311
Location: B

7/05/29 (12)

Seq. #:	Machine Or Operation:	Description :
42.0	QC21	FINAL INSPECTION/W/O RELEASE

(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/29

Job Completion

07/05/29

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

QA COPY ISSUED

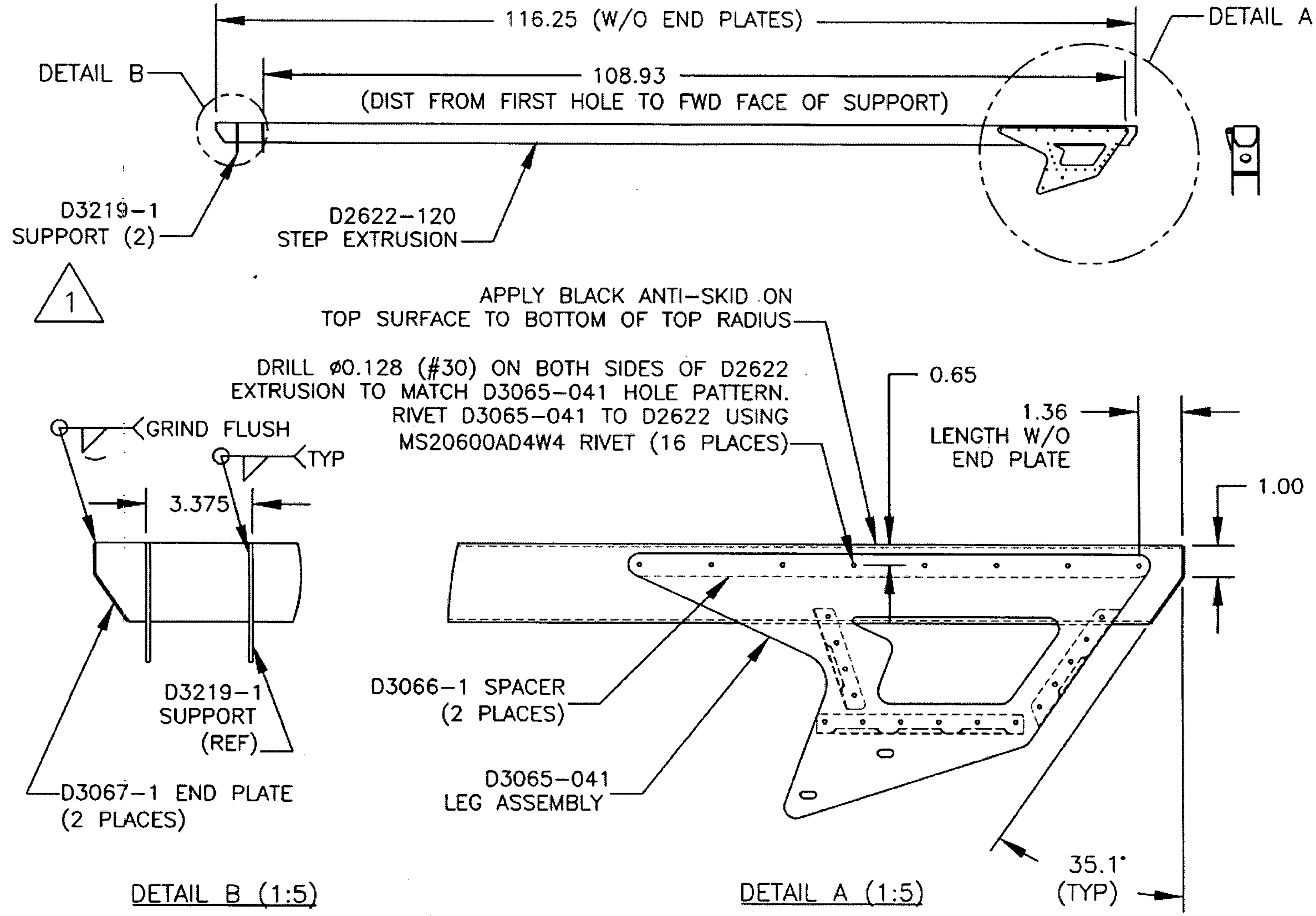
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. A SHEET 1 OF 2
DATE 04.03.01		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	

RELEASED 04.04.05

Part No.	Description	QTY -041	QTY -042
D3272-041	**Step Assembly, High Long (LH)**	**X**	
D3272-042	**Step Assembly, High Long (RH)**		**X**
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

1) –041 SHOWN, FOR –042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



DETAIL B (1:5)

DETAIL A (1:5)

RELEASED 04.04.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. WORK ORDER 3046-3

DART

QA COPY ISSUED

DESIGN	DRAWN BY
CHECKED	APPROVED
DATE 04.03.01	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3272 — REV. A — SHEET 2 OF 2

TITLE: STEP ASSEMBLY, HI LONG — SCALE 1:20